

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577

OUTSTANDING PO REPRINT

Purchase Order ID PO10810

Purchase Order Date 11/20/09

PO Print Date 12/03/09

Page Number 2 of 2

Order From :

MAGNA STAINLESS
5775 RUE KIERAN
ST LAURENT, QC H4S 0A3
CA

VC-MAG002

Contact Name

Vendor Phone 800 363 6646
Vendor Fax 514 339 1105
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB

Line Nbr	Reference Revision ID	Description/ Mfg ID	Req Date/ Taxable	Req Qty	Unit Price	Extended Price
Vendor Part Number						
5	M303R2.000	303 ROUND BAR 2"	11/30/09 Yes	✓ 12.00 Yours ppd <i>f 12-8 f 9/10/2</i>	\$28.7500	\$345.00
			Special Inst:	MATERIAL: 303 ROUND BAR NOTE: 304/316 NOT ACCEPTABLE	Line Total:	\$345.00
					Outstanding PO Total:	\$1,055.04

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

CJ

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 3

Change Date: 11/25/09

Dart Aerospace Ltd.
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Tel: 613 632 9577

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Contact Name	Buyer	Chantal Lavoie
Vendor Phone	Requisition Nbr	
Vendor Fax	Tax Resale Nbr	10127-2607
Vendor Account Nbr	Terms	Net 30
	Currency	CAD
	FOB	

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty	Unit Price	Extended Price
Ship To :	DART AEROSPACE LTD	1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CANADA				

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M303B1.000X2.000	303 BAR 1" X 2"	11/30/09 Yes	12.00 f	Yours ppd	\$41.2500	\$495.00

Special Inst: MATERIAL: AISI 303 STAINLESS BAR
NOTE: 304/316 NOT ACCEPTABLE Line Total: \$495.00

4	M303B1.000X1.000	303 BAR 1" X 1"	11/30/09 Yes	12.00 f	Yours ppd <i>Net 11.8 /c 9/12/03</i>	\$17.9200	\$215.04
					Line Total:		

Special Inst: AS ABOVE Line Total: \$215.04

11/25/09

Lavondo LOIU (VIZCAYA) Espafia
P.O. Box 1.323/48080 Bilbao
Tel. 34-(4) 4 71 13 00
Fax. 34-(4) 4 53 16 36



ACEROS INOXIDABLES

OLARRA

691533

CANADIAN SPECIALTY METALS
81 STEINWAY BLVD.
ETOBIKOKE- ONTARIO M9W 6H6 - CAN

Trade Mark - Zeichen des Lieferwerkes
Anagrama del suministrador

Works Inspector Stamp - Werkssachverständiger
Sello del Inspector



3

Certificate type - APZ Nach Certificado tipo EN 10.204/3.1			Certificate n° - Prüf-Nr Certificado n° 630.235			Date-Datum-Fecha 9 DE ENERO 2009								
Our order N° Werks - Nr Nº de Referencia 398.933		Heat Schmelze Cotada 969444	Your order N° Bestell - Nr Pedido N° 074435-AM											
Steel Grade Werkstoff Calidad AISI-303 /			According to Entsprechend Corresponde ASTM A 582/A582M-05											
Shape and Size - Gegenstad Perfily dimension SQUARE 1"		Tolerance - Toleranz Tolerancia ASTM-A484-06 B		Bundles Bünde Buttos 1	Bars Stäbe Barres 70	Weight Gewicht Peso 2.791LBS								
Requirements - Anforderungen - Exigencias														
<p>SAE AMS 5640U-07.TYP 1 QQ-S-764B-70 Amd.2 COND.A EN 10.088-3.2005</p> <p style="text-align: right;">CP 69.12.04</p>														
Melting process / Erschmelzungsart / Proceso de Fusión E.A.F. / A.O.D.			Heat treatment / Wärmebehandlung / Tratamiento térmico 1.050 , 4 HORAS Water / Wasser / Agua											
Solution annealed/Abgeschreckt/Hipertemperie >> Cold drawn/Gezogen/Estruido														
Test results - Ergebnis der Prüfungen - Resultados de los ensayos														
Dimension of Specimen Abmessung des Probestabes Medida de las probetas		Rp 0.2% N/mm² MPA	Rp 1% N/mm² MPA	RM N/mm² MPA	A %L 5D	A %L 4D	Z %	Hardness Härte Dureza HBW	Impact Test / Kerbschlag / Resiliencia ISO V Jules					
		Min.												
		Max.	KSI	KSI										
Temperature °C 20C	Spec. N° Probe Nr. Pro N° 1	55.691		92.239		49	57	197						
Min.	C	Si	Mn	P	S	Cr	Mo	Ni	Ti	Cu	Co	N		
Max.														
	0,042	0,32	1,66	0,032	0,305	17,60	0,32	8,50		0,46	0,170	0,0330		
Visual and dimensional inspection Besichtigung und Ausmessung Control visual y dimensional			O.K.	Radioactivity inspection Radioaktivitätskontrolle Control de Radioactividad			O.K.	Antimixing test Spektroskopische Verwechslungsprüfung Antimezcla			O.K.	Grain Size Korngröße Tamaño de grano		
Remarks - Bemerkungen - Observaciones														
<p>MECAMAX-PLUS Free from mercury contamination • No Weld Repair. 1.4305.</p>												<p>EDV / EDP Acc. EN 10.204 Alfredo Molina Certification Mng.</p> <p>Works Inspector Der Werkssachverständige Inspector de fábrica</p>		

Acciaierie Valbruna s.p.a.



36100 VICENZA (Italia) - Viale della scienza, 25 z.i.
Stab. 39100 BOLZANO (Italia) - Via A. Volta, 4

Cliente / Besteller/Purchaser:

VALBRUNA CANADA LTD.

8724 HOLGATE CRESCENT

COND-MILTON, ONT L5T 5Z1 CAN

Produttore: ACCIAIERIE VALBRUNA S.P.A.
Hersteller/Produzent/Manufacturer:

Oggetto Prove: Polished Annealed Peeled
Prüfgegenstand: poliertes, annealiertes, abgeschältes

Specifiche:
Anforderungen / Requirements / Especificaciones

VAL CANADA 2-303-A

ASTM A314-97, S30300

DOD-F-24669 6 S30300

(0) SEC-II PT-A 2007 EDITION

Avviso di Spedizione: D-VI08020158
Informationsblatt Versand-Nr.: 6/2008

Ordine n.: 803001929 STOCK
Bestell-Nr.: 00000000000000000000000000000000

Tipo di Elaborazione: E+AOD
Erhöhungslösung/Welting process/Type of elaboration

CERTIFICATO DI COLLAUDO ABNAHMEPRUEFZEUGNIS INSPECTION CERTIFICATE CERTIFICAT DE RECEPTION EN 10204 (2005), 3.1

Certificato nr.: MEST654809/2008/
Prüfungs-Nr.: 00000000000000000000000000000000

Conferma ordine nr.: E108002024
Werkorder-Nr.: 00000000000000000000000000000000

Marchio di Fabbrica:
Zeichen des Lieferanten:
Trade mark:
Doge der Fabrik: Abschluß



MR

Punti/zone del Collaudatore:
Stempel des Werkssachverständigen:
Handstempel des Prüfungsbüros der Industrie:

C/L
CP 09.12.09

ASME SA320 2007-B8F(m)
ASTM A320 2008-B8F
MIL-S-862 B/1 303
QQ-S-764 B/2 303

Disegno: T-303

Versione: 00000000000000000000000000000000

Matrice: VPAU1882 VALPLUS

Materialauszeichnung/Brand-Kennzeichen:

Sono state soddisfatte tutte le condizioni richieste.
Die geforderten Anforderungen sind erfüllt.
Las condiciones requeridas han sido cumplidas.
The requested requirements have been met.
Le matériaux sont en conformité avec les spécifications.

Controllo antimescalanza: OK
Vierkantprüfungen: spezifisch erfüllt durchgeführte
Anschlussprüfung: spezifisch erfüllt durchgeführte
Controle antimescalanza: OK

Controllo visivo e dimensionale: soddisfatta le esigenze:
Besichtigung und Abmessung: ohne Überschreitung
Visual inspection + all dimensions checked satisfactorily
Controlle visuel et dimensionnel: satisfait

Pos. nr. Ref. n. Num. o. Nº de ref.	Disegno/ Diagramm/ Produktzeichnung/ Orientierung Dimensions/ Abmessungen/ Dimensions du produit	Dimensioni: mm Abmessungen: Dimensions: Orientation	Tolleranza: Toleranz: Aléatoire: Tolerance	Lunghezza - Ft Länge - Length Longueur	Colata: Schmelze: Welt: Coulée	Pezzi: Stückzahl: Peces: Pieces	Peso: LB Gewicht: Weight: Poids	Lotto nr. Liefer- Nr.: Lote nr.
0020	Rondò	2.0000	484-06B	12/13	422074	2	10.285	80650590

TEST	Prova/Prüfung/ Prueba/Prueba Dimensioni: Durchmesser: Width: Dicke: Thickness: Largura: Espesor: mm	Prof.: Sagge: Profundidad: Profundité:	Snervamento: Evidenziare: Vorwärts: Riposo: R.0.2% K.S.I.	Snervamento: Schnäppen: Vorwärts: Unterdruck:	Resistenza: Tensile Strength: Tensión: Tension: Tension: Tension:	Allungamento: Elongation: Verlängerung: Allongement:	Strizione: Friction: Friction: und grado: RA	Resistenza: Tensione: Pres. Vale: Resistance:	Durezza: Hardness: Dureté: HB
Avalori richiesti: I	min: Ansprüche Mindestwerte: Valeurs demandées: Valores mínimos:	max: max: L:	30:	-	75:	-	35:	-	50:
A	12,5	68	L	45	69	-	52	-	58
									184

Produced without class I-II Ozone depleting substances.

Solution heat treated free from continuous carbide network.

Annealing temperature: 1940°F for 1.5h/water.

Micro and macro etch test: OK

Material is DFARS Compliant.

Método and manufactured in Italy. No welding or weld repair. Material free from Mercury or /radioactivity contamination
The Quality Management System is Certified acc. Pressure Equipment Directive (97/23/EC) Annex 1, x.3 by TÜV and LLOYD'S

Vicenza, 15/07/08
vocca:
Atto: voto

Il collaudatore di stabilimento / der Werkssachverständige / Works Inspector / L'agent d'essai

M.Rizzotto

Pagina - 1 di 1

SOLD TO:
DART AEROSPACE LTD
 1270 ABERDEEN STREET

HAWKESBURY , ON
 K6A 1K7
 Contact: CHANTAL

SHIP TO:
DART AEROSPACE LTD
 1270 ABERDEEN STREET

HAWKESBURY , ON
 K6A 1K7
 Ship Terms: PREPAID



SPECIAL INSTRUCTIONS

ASA#

MIKONIA
MTR:Y

Currency	Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS	ERYCK BLAIS	(613) 632-5200	(613) 632-1053	P0010810	
Sales Order	Terms	Ship Via	Date Ordered	Date Required	Date Shipped
W021807	NET 30 DAYS	NIR:R-557065-1	11/20/09	12/03/09	12/03/09

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
1		PC	STAINLESS ROUNDS SRB 303 2" x R/L 12'8" 136 LB / 1 PC	L034043	422074	1
1		PC	STAINLESS SQUARES SSQ 303 CD 1" x R/L 11'8" 40 LB / 1 PC	L034044	969444	1
Bundles: 1				Approx	Weight:	176 LB

Received by: _____ Date: _____ Signature: _____

Purchase Order Receipt Listing

Page 1 of 1

December 04, 2009 6:20:45 AM

All amounts are calculated in domestic currency.

All Vendors PO ID PO10810 Receipt Dates from 12/4/2009 to 12/4/2009 All Line Item Types

All Item ID/GL/WOs All Rec. Employees All Currencies

Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID	Vendor Name	VC-MAG002	Magna Stainless								
PO10810	4		M303B1.000X1.000 f		11/30/2009	12/4/2009	11.8000	\$17.92	0.0000	0	\$211.46
CAD	No		303 BAR 1" X 1"	f		12.0000	Stores		\$211.46	0.0000	0
			113341								
	5		M303R2.000	f	11/30/2009	12/4/2009	12.8000	\$28.75	0.0000	0	\$368.00
	No		303 ROUND BAR 2"	Each		12.0000	Stores		\$368.00	0.0000	0
			113341								
											Total Received Quantity: 24.6000
											Total Qty to Inspect (PO U/M): 0.0000
											Total Reject Quantity: 0.0000
											Total Receipt Value: \$579.46
											Total Balance Due Quantity: 0.2000

Receiving Report

Date: 9/12/3

Supplier: MAGNA

Batch No: M113341

Dart P/O: 10810

Packing Slip: Yes No
 Invoice: Yes No
 Receipt: Cash Cr

Release Note Attached: Yes No N/A
 Waybill Attached: Yes No N/A
 Shipment Complete: Yes No N/A
 QC6 Inspection N/A
 Work Order est. 2 top N/A

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
<u>M303B1-000 XA-000</u>		<u>10</u>	<u>0</u>	<u>0</u>	<u>12</u>	

Initials of receiver (if shipment OK) C Level 12 C

Production/Admin:

9/12/4

Location

Date

Received/Costing

Initial

DART AEROSPACE LTD	Work Order:	62730
Description: Sill Fitting	Part Number:	N4111-1
Inspection Dwg: N4111 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

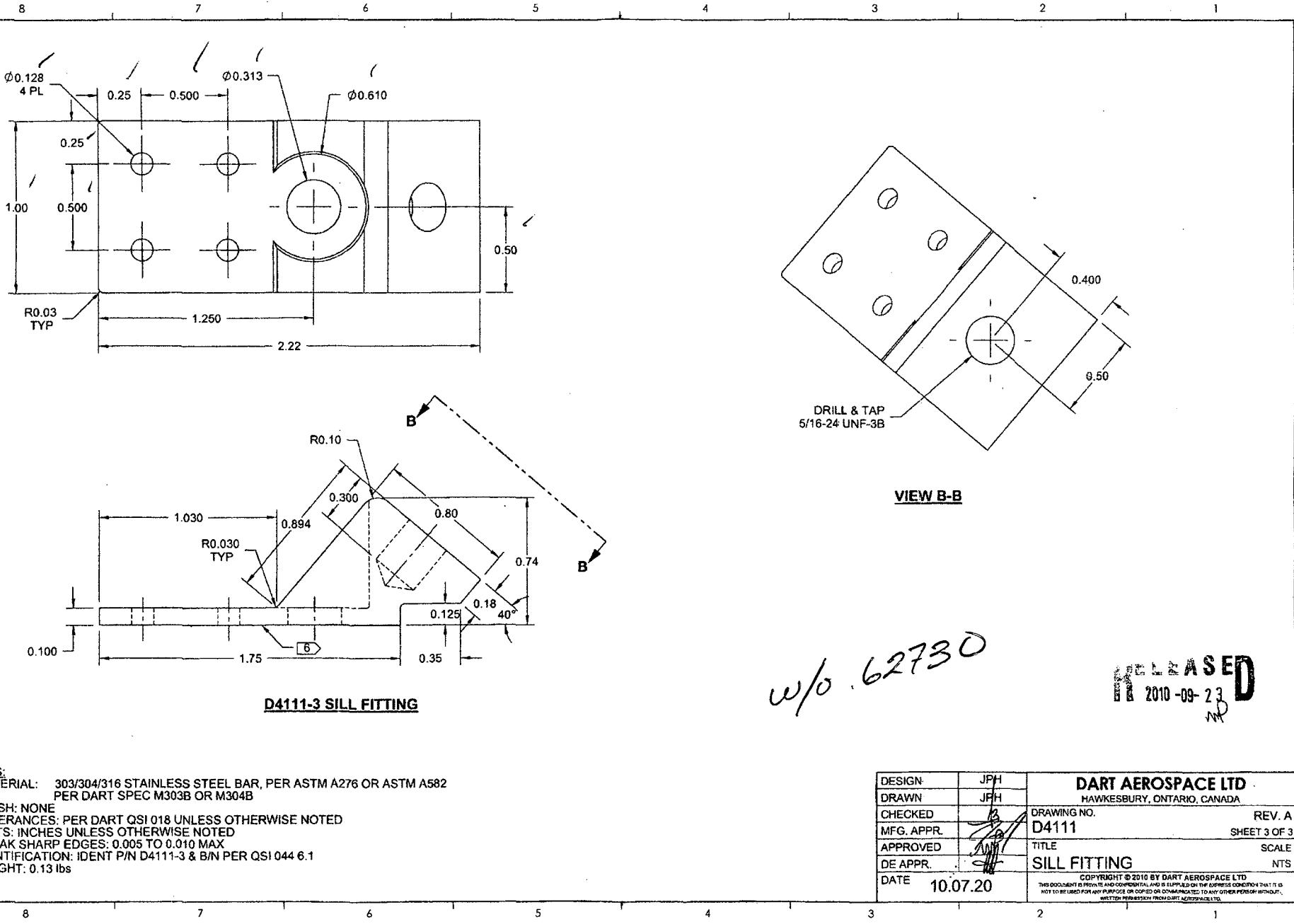
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+-.030	.985	✓		Verif. JI-3	
.500	+.010	.500	✓		"	
.25	+.030	.244	✓		"	
ϕ .128	+.005 -.001	.128	✓		"	
.25	+.030	.250	✓		"	
.500	+.010	.500	✓		"	
ϕ .313	+.006 -.001	.314	✓		"	
.610	+.010	.610	✓		"	
.50	+.030	.494	✓		"	
.222	+.030	.2730	✓		"	
1.250	+.010	1.760	✓		"	
.03	+.030	.030	✓		R-G	
.100	+.010	.095	✓		Verif. JI-3	
1.540	+.010	1.539	✓		"	
.300	+.010	.303	✓		"	
.800	+.010 -.030	.801	✓		"	
.74	+.030	.742	✓		"	
40°	+.5°	40°	✓		Protractor	
.18	+.030	.188	✓		Verif. JI-3	
.125	+.010	.125	✓		"	
.35	+.030	.325	✓		"	
.226	+.030	.2286	✓		"	
.400	+.010	.400	✓		"	
.50	+.030	.494	✓			

Measured by:	SJ
Date:	10/10/14

Audited by:	JL
Date:	10.10.15

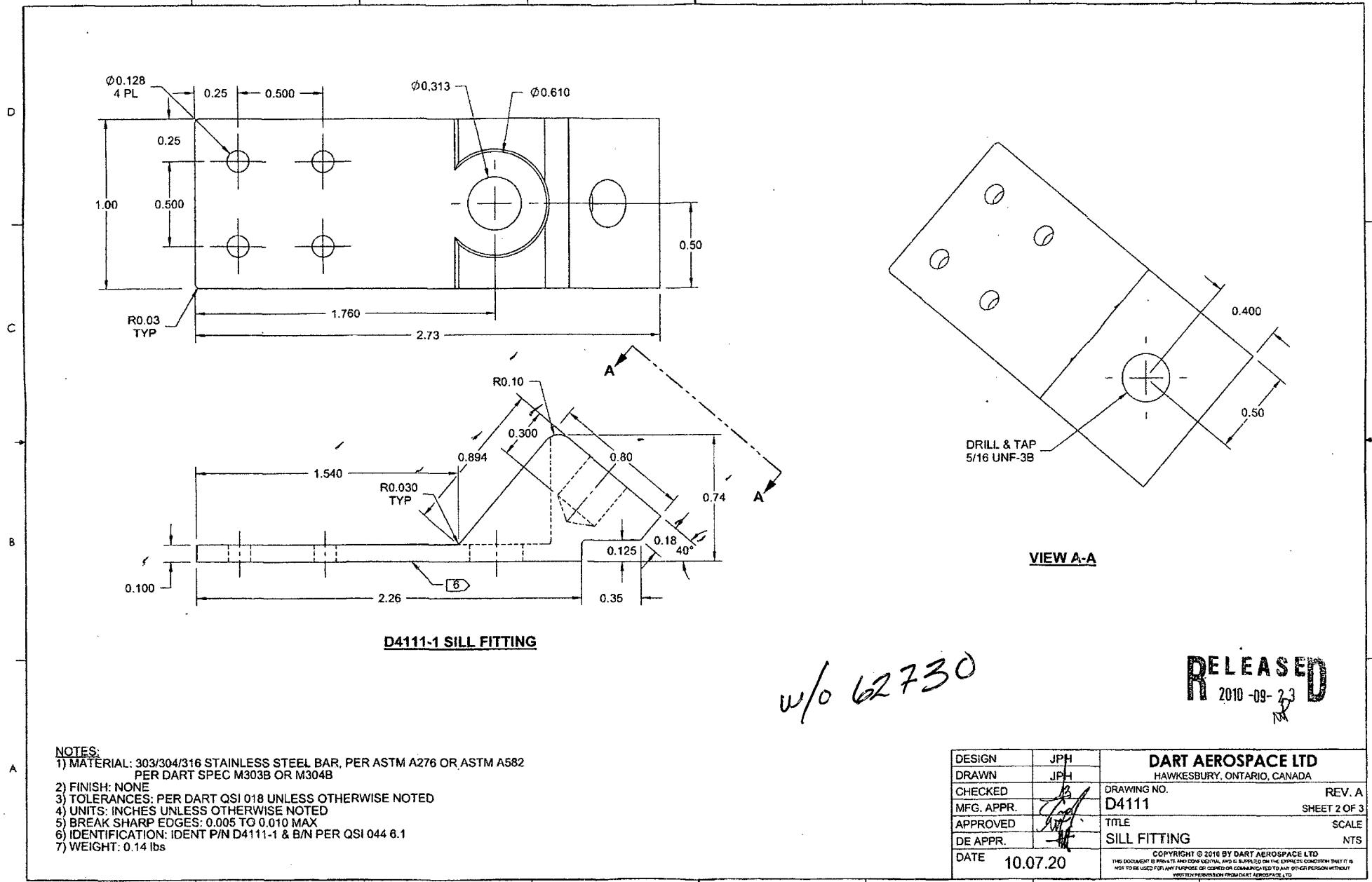
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



DESIGN	JPH	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. A
MFG. APPR.	<i>[Signature]</i>	D4111 SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	SILL FITTING NTS
DATE	10.07.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS RESTRICTED FROM REPRODUCTION AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

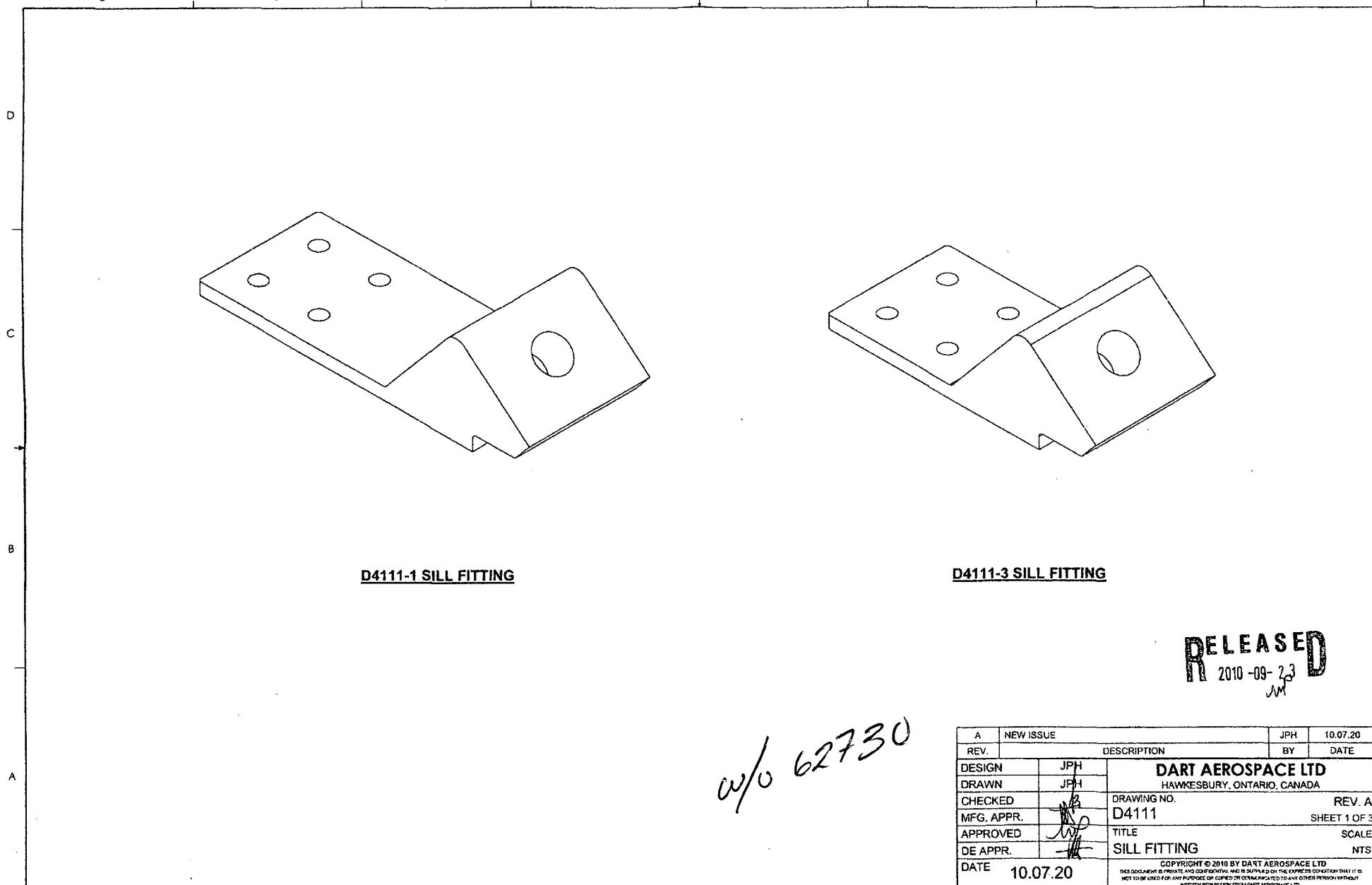
8 7 6 5 4 3 2 1



DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	
MFG. APPR.	JPH	D4111	REV. A
APPROVED	JPH	SHEET 2 OF 3	SCALE
DE APPR.	JPH	TITLE	NTS
DATE	10.07.20	SILL FITTING	

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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

Eric Charbonneau

From: Bill Beckett [bbeckett@dartaero.com]
Sent: September 29, 2010 3:56 PM
To: 'Eric Charbonneau'; 'Chris Provencal'; 'Mike Petsche'; 'David Shepherd'
Cc: 'Linda Lacelle'
Subject: RE: 350 skid swaging

All - We currently ship 100-120 350 skidtubes per year vs. ~150 Bell Med skidtubes per year. Clearly we want to proceed with the Bell Med first because of the potential savings and the fact that it will be "simple" from an Eng'g and Mfg pov to make the change.

I believe it is worth it to make a change for the 350 as well, but it will be more complex. It would be nice, for example, if we could standardize crossbolt spacer sizes.

Eric – I would like to see a recommended approach (please work with Eng'g), how much it would cost and what we would save annually through your recommended approach.

Bill

From: Eric Charbonneau [mailto:echarbonneau@dartaero.com]
Sent: September 24, 2010 12:41 PM
To: Beckett, Bill; Chris Provencal; Mike Petsche; David Shepherd
Cc: Linda Lacelle
Subject: 350 skid swaging

Did some testing for swaging spacers on 350 skid... results are good, the fact that there is no ridge on the extrusion does not affect the swaging process. The other problem now... that Dan Paquette pointed out that there is no c'bore on the 350 skids and the swaging process creates a c'bore... not sure what engineering thinks of that. I did some research and we could try to use 5/8" x .083" wall 304 Stainless Steel mat'l for the X-bolt spacers instead of 5/8" x 0.065" wall aluminum (that size tubing is only available in SS) for the D2743 spacers expand them to .484" (as per dwg D2750), there is a tool available for that diameter and I can order it in the long version which would enable us to swage up to 2.250" deep per side therefore overlapping the c'bore effect and hopefully end up with a perfect 0.480" diameter straight thru... just thinking outside box here might not make much sense. For D3490-1 spacer we could expend them as per dwg using .065" instead of 0.049" but no long version tool available so we can't eliminate the c'bore effect. For D3490-3 spacers we would need to go to a SS version in order to achieve proper inner diameter and for D3490-5 forget about it there is no tool available for any 5/16" OD tubing.... I know it's complicated, basically what I'm trying to say is that for the 350 skid there would be a lot of engineering changes required in order to swage the x-bolt spacers.

ERIC CHARBONNEAU
Production Engineering Coordinator



T(613) 632-5200
F(613) 632-1053
echarbonneau@dartaero.com

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Picklist Print

Page 1

October 6, 2010 2:02:38 PM

Work Order ID: 62730



Parent Item: D4111-1



Parent Item Name: Sill Fitting

Start Date: 12/10/2010

Required Date: 15/10/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A NEW ISSUE 10-09-24 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.000X1.000 303 BAR 1" X 1"		Purchased	No			100	f	13.3889	0.24	0.757895		JL 10/10/12	

Location	Loc Qty	Loc Code
MAT	12	
115555	12	
MAT53	1.38892	
113341	0.15996	.76
113719	1.22896	

Work Order ID 62730

Page 3

October 6, 2010 2:02:39 PM

Item ID: D4111-1

Accept



Setup Start



Revision ID:

Item Name: Sill Fitting

Stop



Start Date: 12/10/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 15/10/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

Work Order ID 62730

Page 2

October 6, 2010 2:02:39 PM

Item ID: D4111-1

Accept



Setup Start



Revision ID:

Item Name: Sill Fitting

Stop



Start Date: 12/10/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 15/10/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

JL/6/16/14

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

JUL 10 10 15

(3) J

140



Packaging

Packaging

Identify as per dwg & Stock Location: 128

0.00

D.D.

Memo

0.00

C 10/10/15 (3)

Work Order ID 62730

Page 1

October 6, 2010 2:02:39 PM

Item ID: D4111-1

Accept



Setup Start



Revision ID:

Item Name: Sill Fitting

Stop



Start Date: 12/10/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 15/10/2010 Req'd Qty: 3.00



Customer:

Reference:

10/10/10

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4111	A

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK TO 2.855" LONG

SL 10/10/12

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MILL AS PER DWG AND FOLIO FA965

DWG REV: AFOLIO REV: AA*SL 10/10/12*

2-DEBURR